

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024371**Date Inspected:** 05-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Shi Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 009365

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Segment 13CW. The weld designations reviewed are as follows:

1. SEG3015B-170, 174, 178, 182, 186, 190, 194, 198, 202
2. SEG3015B-206, 210, 214, 218, 222, 226, 230, 234, 238

OBG Trial Assembly Yard

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint SEG3015H-353 located on vertical plate stiffener at panel point 123 to 123.5 CW side of OBG Segment 13CW. ZPMC Welder is identified as 045240. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-ESAB.

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Shielded Metal Arc Welding (SMAW) welding of weld joint SEG3015D-279 located on Deck Panel to Deck panel Diaphragm at panel point 124 CW Side of OBG Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3015F-256 located on Deck Panel to Deck panel Diaphragm at panel point 123.5 CW Side of OBG Segment 13CW. ZPMC Welder is identified as 045196. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3015U-002 located on Deck Panel to Vertical Plate at panel point 122.5 to 123.5 CW Side of OBG Segment 13CW. ZPMC Welders are identified as 068097, 066156 and 067947. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-Tc-U4b-FCM-1.

SMAW welding of weld joint SEG3015N-041, 042 located on Longitudinal Diaphragm RS stiffener at panel point 122.5 of OBG Segment 13CW. ZPMC Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-FCM-1.

SMAW welding of weld joint SEG3014N-169 and 170 located on Longitudinal Diaphragm RS stiffener at panel point 120.5 of OBG Segment 13BW. ZPMC Welder is identified as 067765. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-P-2214-FCM-1.

SMAW welding of weld joint SEG3015A-008 located on bottom plate to side plate at panel point 124.5 CW Side of OBG Segment 13CW. ZPMC Welder is identified as 067588. ZPMC Quality Control (QC) is identified as Mr. Shi Lei. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21193.

This QA inspector observed ZPMC personnel performed Ultrasonic Testing (UT) on side plate RS stiffener to Floor Beam of OBG Segment 14W. The panel point is identified as PP126 at cross beam side.

SMAW welding of weld joint SEG3020A*-004 located on bottom plate to side plate at panel point 124.5 to 125 CW Side of OBG Segment 14W. ZPMC Welder is identified as 066002. ZPMC Quality Control (QC) is identified as Mr. Zhu Lin. The welding variables recorded by QC appeared to comply with the Applicable WPS-345-SMAW-4G-(4F)-FCM-Repair-1, which is used as per Welding Repair Report (WRR) B-WRR-21195.

See the attached picture.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Vibin

Quality Assurance Inspector

Reviewed By: Patel,Hiranch

QA Reviewer